

Work Order ID 67694

Tuesday, March 29, 2011 1:00:14 PM



Page 1

Item ID: D4150-041

Accept



Setup Start



Revision ID:

Item Name: Attachment Arm Assembly

Stop



Start Date: 3/29/2011 Start Qty: 4.00

Required Date: 4/1/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4150

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

11/03/29 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/29

(2)

120

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

134

11/3/30 200

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/3/31
MF
11-03-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:00:21 PM

Page 1

Work Order ID: 67694

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly






















































































































Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A  Bolt		Purchased	No			100	Each	32.0000	2	8			
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													
													

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 1:00:22 PM

Page 2

Work Order ID: 67694

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

100

Each

1,138.000

2

8



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

FP-B

18

112314

18

ST301

1040

112314

1040



EPB 11/03/29

NAS1149C0332R

Purchased

No

100

Each

277.0000

4

16



Washer

Location

Loc Qty

Loc Code

ST297

277

115832

46

116304

231



EPB 11/03/29

Tuesday, March 29, 2011 1:00:22 PM

Shop Packet Print

Page 2

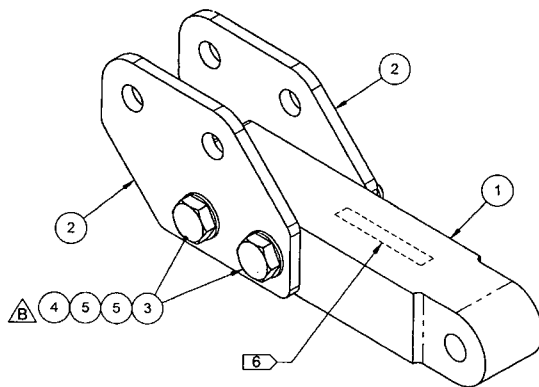
W/O:		WORK ORDER CHANGES						
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D4150-041 ATTACHMENT ARM ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67684

PL 11-0329

RELEASED
2010-07-16
MB

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B	MB	10.07.08
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4150** REV. B
SHEET 1 OF 3
TITLE **ATTACHMENT ARM ASSY** SCALE NTS

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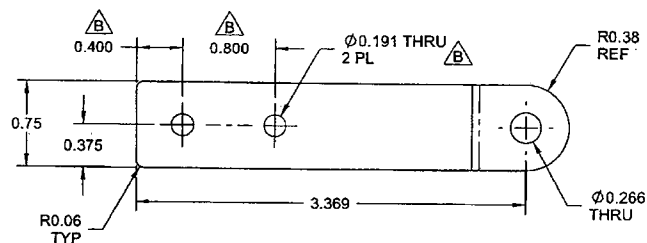
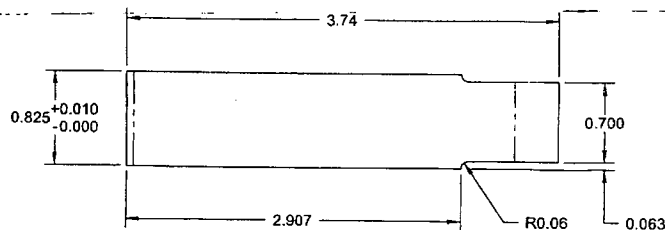
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

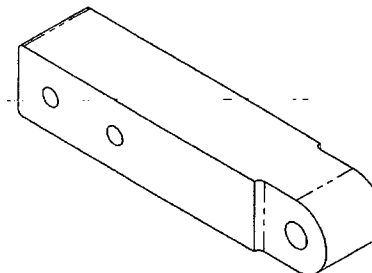
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NOTE: Date & initial all entries



D4150-1 ARM



w/o 67694

RELEASED
2010-07-16
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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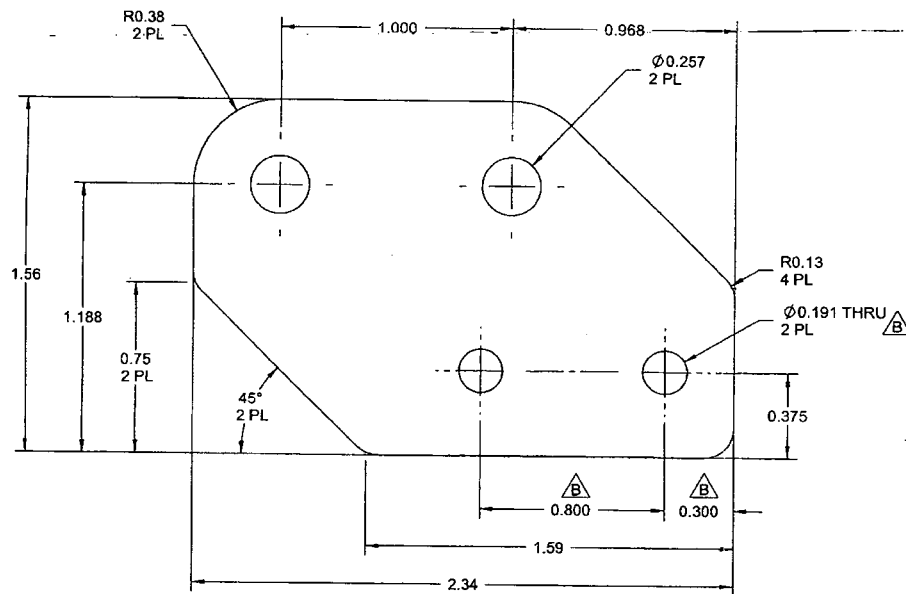
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



W/O 67694

D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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